



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D117-840-011
Job Sheet 186606



Part No: D117-840-011

Job Qty: 1 ea

Part Name: BK117/EC145 Bearpaws with Wearplates



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/18/18

Job Tracking No:

Due Date: 11/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP REV:A NEW ISSUE 13-04-01 JLM VERIED BY:DD IPP REV:B 13.05.28 PER IIN D117-840
REV.A DD VERF:JLM IPP REV:C 15.03.30 PER REV B JLM VERIFIED BY:DD IPP REV:D 16.02.23 PER IIN
REVC DD VERF:JLM

Ship Via:

06630

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/30/18	11/30/18	0.00	0.00	Start Up Stores/Pkg-2	9-89	NOV 22 2018
160	Packaging	1 pcs	11/30/18	11/30/18	0.00	0.00	Packaging1-1	9-89	NOV 22 2018
170	QC	1 pcs	11/30/18	11/30/18	0.00	0.00	QC4	9-89	NOV 29 2018
180	Packaging	1 pcs	11/30/18	11/30/18	0.00	0.00	Packaging3-1	9-89	NOV 29 2018
185	DC	1 pcs	11/30/18	11/30/18	0.00	0.00	DC	9-89	NOV 29 2018
190	QC21-FG	1 Ea	11/30/18	11/30/18	0.00	0.00	QC21	9-89	NOV 29 2018

Part Op 180 - Identify and pack for shipping as per PPP D117-840-011
Descriptions: 185 - Photocopy bluefile & type labels per PPP D117-840-011 CHG 003

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4C11A	Bolt	12 Ea (12 ea)	90-Start up Operation	5089546
AN4C17A	Bolt	8 Ea (8 ea)	90-Start up Operation	5083220
D2274	Radius Block	8 Ea (8 ea)	90-Start up Operation	509735
D3456-1	Washer	8 Ea (8 ea)	90-Start up Operation	5079335
D4012-3	Cushion	4 Ea (4 ea)	90-Start up Operation	5046542
D5377-1	Bearpaw	2 Ea (2 ea)	90-Start up Operation	5047364
D5378-041	Bearpaw Wearplate Assembly	2 Ea (2 ea)	90-Start up Operation	5097359
D5379-1	Bearpaw Clamp	4 Ea (4 ea)	90-Start up Operation	5109103
MS21043-4	Nut	20 Ea (20 ea)	90-Start up Operation	5092684
NAS1149D0463J	Washer	12 Ea (12 ea)	90-Start up Operation	50304717 509278025

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4C11A	12	133	0
	AN4C17A	8	53	0
	D2274	8	41	0
	D3456-1	8	251	0
	D4012-3	4	73	0
	D5377-1	2	9	0
	D5378-041	2	10	0
	D5379-1	4	22	0

WORK ORDER N ON-COMFORMANCE / UPDATE

QA Closed: _____ Date: _____

Date :	Step #:
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Description Work Order Deviation

Approval

Root Cause			FAULT CATEGORY			
Environment		No Re-verification	Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong
Design		Operator	Bending	Set-up	Folio/Program	Outside Dimensions
Doc/Data		Offset/Setup	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance
Equip/Tooling		Supplier	Cracks	Broken/Damage/Defect	Weld	Part Incorrect
Handling/Pre		Training	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing
Material		Use for Testing	Cuffs	Contamination	Out of Sequence	Part Moved
Internal Transport		Poor Information	Crushing	Countersink	Off-set	Drawing
Tribal Knowledge		Rushing	Heat Treat	Cut Too Short	Mislabeled	Finish
LOA		Product Improvement	Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function	Misread
Substation		Process Improvement	Marks/Chatter	Drill Holes	Misaligned/off center	Turning Sequence
Past Expiry Date		Manufacturing Process				
Misidentified		Past Due	OTHER :			

MS21043-4
NAS1149D0463J

20
12

763
2,662

0
0

Part Specifications

Specifications could not be found.

Plex 11/19/18 8:21 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due		☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter		FAULT CATEGORY ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
				OTHER : ☐							

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D117-840-011 <i>Bearpaw Installation</i>	27.7 lb 12.6 kg	0.0 in 0.0 mm	0.0 lb-in 0.0 mm-kg	204.1 in 5200 mm	5653 in-lb 65,520 mm-kg

5.0 PARTS LIST

QTY -011	Part Number	Description
X	D117-840-011	BEARPAW INSTALLATION
8	D2274	RADIUS BLOCK
8	D3456-1	WASHER
4	D4012-3	CLAMP CUSHION (REPLACES D4012-1)
2	D5377-1	BEARPAW (REPLACES D4796-1)
2	D5378-041	BEARPAW WEARPLATE ASSY (REPLACES D4798-041)
4	D5379-1	BEARPAW CLAMP (REPLACES D4799-1)
12	AN4C11A	BOLT
8	AN4C17A	BOLT
20	MS21043-4	NUT
12	NAS1149D0463J	WASHER

REFERENCE ONLY

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Change Record

PAGE 1 OF 1

Part Number: D117-840-011

Description: BEARPAW[illegible]

